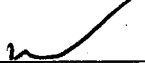


Date: Tuesday, 15/08/2006 7:50:11 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28111
 Estimate Number : 12108
 P.O. Number : N/A
 This Issue : 15/08/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : 10/08/2006 Type : MACHINED PARTS
 Previous Run : N/A
 Written By : 
 Checked & Approved By :
 Comment : Est Rev: A Removed from 9 Digit 06-01-25 JLM

Drawing Name : DOUBLER
 Part Number : D32013
 Drawing Number : D3201 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 21/08/2006 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.0473 sf(s)/Unit Total: 0.9450 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick
 (M2024T3S.050)
 Batch: M19053

MF 06 08 16

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

MF 06 08 16

(20)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MF 06 08 17

(20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06-08-20 (20) count

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr Stack

MF 06-08-21

(20)

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Bend as per Dwg D3201

06/08/21 20

(PTO)

15

Date: Tuesday, 15/08/2006 7:50:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28111

Part Number: D32013

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

OL 06/08/29

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST413

RB 06/08/30

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/30

Job Completion





C 206/08/30

P-70 ->

Date: Thursday, 10/08/2006 9:56:19 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 28111	
Estimate Number : 12108	
P.O. Number :	Part Number : D32013
This Issue : 10/08/2006 S.O. No. :	Drawing Number : D3201 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run :	Material :
Written By : 	Due Date : 21/08/2006 Qty: 20 Um: Each
Checked & Approved By : 	
Comment : Est Rev: A Removed from 9 Digit 06-01-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S050	2024-T3 .050 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0473 sf(s)/Unit Total : 0.9450 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.050" thick
(M2024T3S.050)
Batch: M19053

W. Lafont
06 08 16 (20)

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
Cut blanks: 3.825" x 1.725" grain along 1.725"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
Machine D3201-3/-4 as per Folio FA337 and Dwg D3201

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06 08 17 (20)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: R Date: 06/08/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	6	1 part out of tolerance on set-up.	<u> AS </u> 06/08/21	Scrap: destroy	<u> SB </u> 06/08/21	<u> Z </u> 06-08-21	<u> AS </u> 06/08/21	<u> Z </u> 06-08-21

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 9:56:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28111

Part Number: D32013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Bend as per Dwg D3201

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

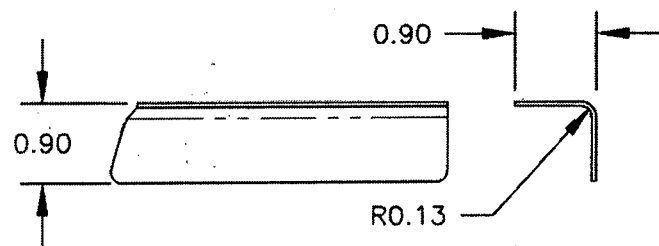
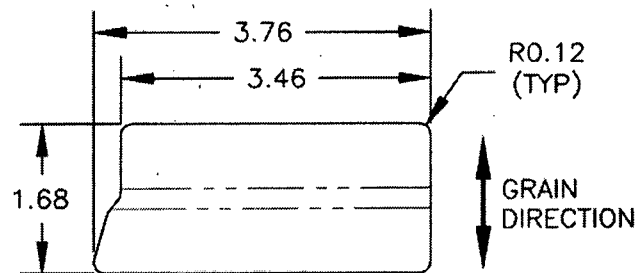
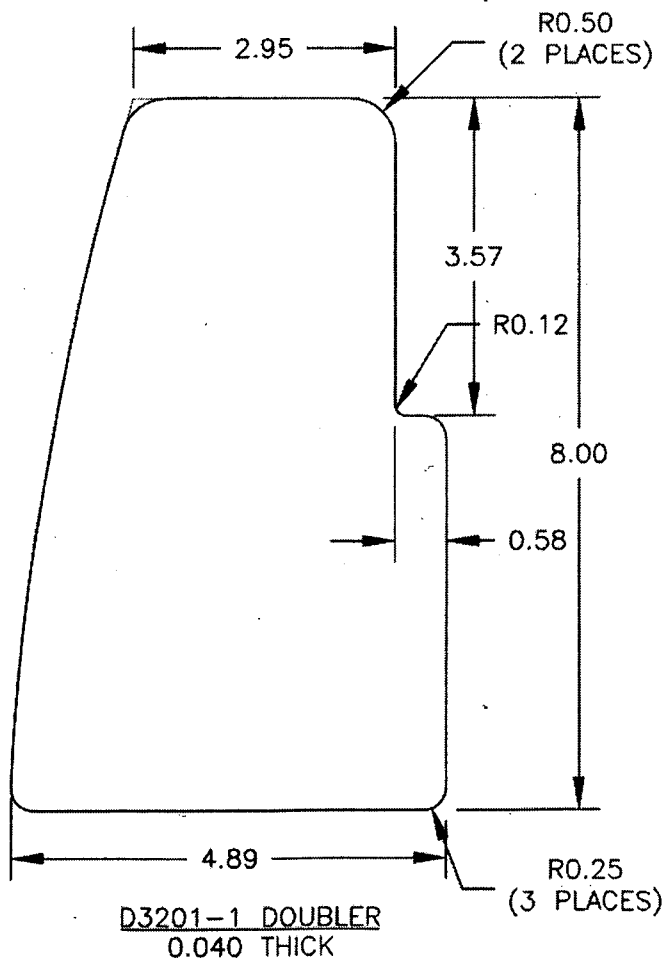
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	<i>[Signature]</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3201	SHEET 1 OF 1
DATE	03.11.03	TITLE	DOUBLER	SCALE	1:2
A	03.08.07	NEW ISSUE			
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4			

RELEASED
03.11.14 *[Signature]***D3201-1/-3/-4 DOUBLER**

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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